

Work Order ID 144080

Friday, April 01, 2016 10:21:43 AM

144080

Page 1

Item ID: D412-814-020 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Crew Door RH,Full Bubble Window
 Start Date: 4/1/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 4/4/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: UMF Date: 16-4-1 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D412-814	C								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-814-020 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MW 16-04-14
 DAS 27 9-89
 APR 15 2016
 DAS 28 9-89
 APR 14 2016

DAS 27 9-89
 APR 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Work Order ID 144080

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144080

Page 2

Item ID: D412-814-020

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Crew Door RH, Full Bubble Window

Start Date: 4/1/2016

Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/4/2016

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-814-020

Location: FG091

APR 18 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

APR 18 2016

ML5

mf
16-4-18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐			
Misidentified ☐	Past Due ☐				

Picklist Print

Page 1

Friday, April 01, 2016 10:21:41 AM

Work Order ID: 144080

144080

Parent Item: D412-814-020

D412-814-020

Parent Item Name: Replacement Crew Door RH, Full Bubble Window

Start Date: 4/1/2016

Required Date: 4/4/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.06.13 NEW ISSUE DD VERF:EC
12.12.05 AS PER IIN REV.B DD verf:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4491-042 *D4491-042* Door Hinge Assembly, Right Upper		Manufactured	No				Each	1.0000		1		DAS 6 9-89	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST106				1					
				113961				1					
D4491-044 *D4491-044* Door Hinge Assembly, Right Lower		Manufactured	No				Each	1.0000		1		DAS 6 9-89	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST106				1					
				129387				1					
D4583-042 *D4583-042* Door Assembly, Full Vertical Reference Window, RH		Manufactured	No				Each	0.0000		1			DAS 28 9-89
D4643-1 *D4643-1* Placard		Manufactured	No				Each	6.0000		1			DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST116				6					
				138528				6					

APR 1 1 2016

B142314

APR 1 4 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ * Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Friday, April 01, 2016 10:21:41 AM

Work Order ID: 144080

144080

Parent Item: D412-814-020

D412-814-020

Parent Item Name: Replacement Crew Door RH,Full Bubble Window

Start Date: 4/1/2016

Required Date: 4/4/2016

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

Each

192.0000

6.

AN3C6A

Bolt

DAS
28
9-89

DAS
8
9-89

BAS
27
9-89

Location

Loc Qty

Loc Code

CA	31	
m128704	31	
FG	10	
122416	10	
FP001	40	
m128769	22	
m133363	5	
m133990	13	
ST338a	6	
m133077	6	
ST349	105	
m132767	4	
m133694	1	
m134502	100	

APR 14 2016

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
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OTHER : ☐					

Picklist Print

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Friday, April 01, 2016 10:21:41 AM

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Parent Item: D412-814-020

D412-814-020

Parent Item Name: Replacement Crew Door RH, Full Bubble Window

Start Date: 4/1/2016

Required Date: 4/4/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

Each

1,241.000

6

MS21043-3

Nut

**

DAS
27
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG 80

103691 80

FP001 11

m130673 11

GA 9

m130673 9

OVER007 800

m133990 400

m134502 400

ST302 214

m133577 214

ST304 106

m131340 106

ST308 21

m132551 21

NAS1149C0332P

NAS1149C0332
R

Purchased

No

Each

0.0000

12

NAS1149C0332P

not a goog # see NAS1149C0332R

**

134474

DAS
27
9-89
DAS
28
9-89

DAS
27
9-89

APR 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Description Work Order Deviation		Disposition		Completed By	
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				QC / QA Coordinator Approval	
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OTHER : ☐					

5.0 PARTS LIST, MEDIUM BELL REPLACEMENT DOOR

QTY -011	QTY -012	QTY -013	QTY -014	QTY -015	QTY -016	QTY -017	QTY -018	QTY -019	QTY -020	PART NUMBER	DESCRIPTION
X										D412-814-011	LH DOOR, STANDARD FLAT WINDOW
	X									D412-814-012	RH DOOR, STANDARD FLAT WINDOW
		X								D412-814-013	LH DOOR, HALF HEIGHT COMFORT WINDOW
			X							D412-814-014	RH DOOR, HALF HEIGHT COMFORT WINDOW
				X						D412-814-015	LH DOOR, HALF HEIGHT BUBBLE WINDOW
					X					D412-814-016	RH DOOR, HALF HEIGHT BUBBLE WINDOW
						X				D412-814-017	LH DOOR, FULL HEIGHT COMFORT WINDOW
							X			D412-814-018	RH DOOR, FULL HEIGHT COMFORT WINDOW
								X		D412-814-019	LH DOOR, FULL HEIGHT BUBBLE WINDOW
									X	D412-814-020	RH DOOR, FULL HEIGHT BUBBLE WINDOW
1		1		1		1		1		D4491-041	LH UPPER HINGE ASSY
	1		1		1		1		1	D4491-042	RH UPPER HINGE ASSY
1		1		1		1		1		D4491-043	LH LOWER HINGE ASSY
	1		1		1		1		1	D4491-044	RH UPPER HINGE ASSY
1										D4582-041	DOOR ASSY, FLAT WINDOW, LH
	1									D4582-042	DOOR ASSY, FLAT WINDOW, RH
								1		D4583-041	DOOR ASSY, FULL BUBBLE, LH
									1	D4583-042	DOOR ASSY, FULL BUBBLE, RH
		1								D4584-041	DOOR ASSY, HALF COMFORT, LH
			1							D4584-042	DOOR ASSY, HALF COMFORT, RH
				1						D4585-041	DOOR ASSY, HALF BUBBLE, LH
					1					D4585-042	DOOR ASSY, HALF BUBBLE, RH
						1				D4586-041	DOOR ASSY, FULL COMFORT, LH
							1			D4586-042	DOOR ASSY, FULL COMFORT, RH
						1	1	1	1	D4643-1	PLACARD
6	6	6	6	6	6	6	6	6	6	AN3C6A	BOLT
6	6	6	6	6	6	6	6	6	6	MS21043-3	NUT
12	12	12	12	12	12	12	12	12	12	NAS1149C0332P	WASHER